

Date: Monday, 04/05/2009 1:07:24 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEB
<b>Job Number</b> : 47707	
<b>Estimate Number</b> : 10498	
<b>P.O. Number</b> :	<b>Part Number</b> : D2739
<b>This Issue</b> : 04/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2739 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 47681	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/05/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>C 209/05/04</u>	
<b>Comment</b> :	
Est Rev: C 02.11.28 Reformat KJ	
Est Rev: D 06-03-21 As Per Rev C JLM	
Est Rev: E 07-07-28 As per Rev D JLM	Verified By:

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D26005108	Extrusion 'I Beam' thin
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5

Web

B38589

④

K 9-5-4

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd end of extrusion and Deburr holes and ends.

5-Dburr

K 9-5-4

④

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

8 02/05/04

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 47707

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

④

119-5-4

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 9-5-4

④

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock  
Location: LG

④

119-5-4

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/05

Job Completion



MF 09-05-04

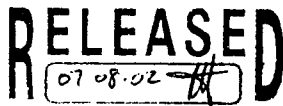
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

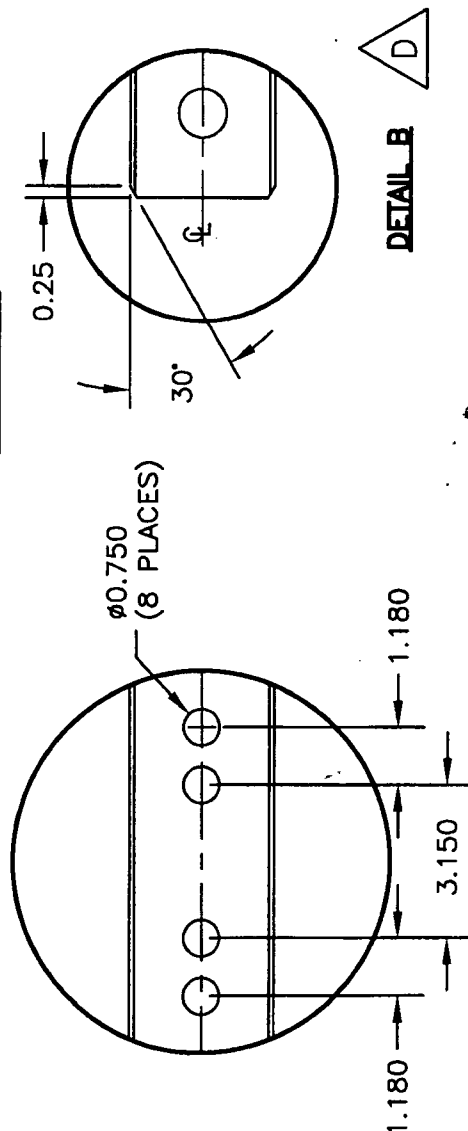
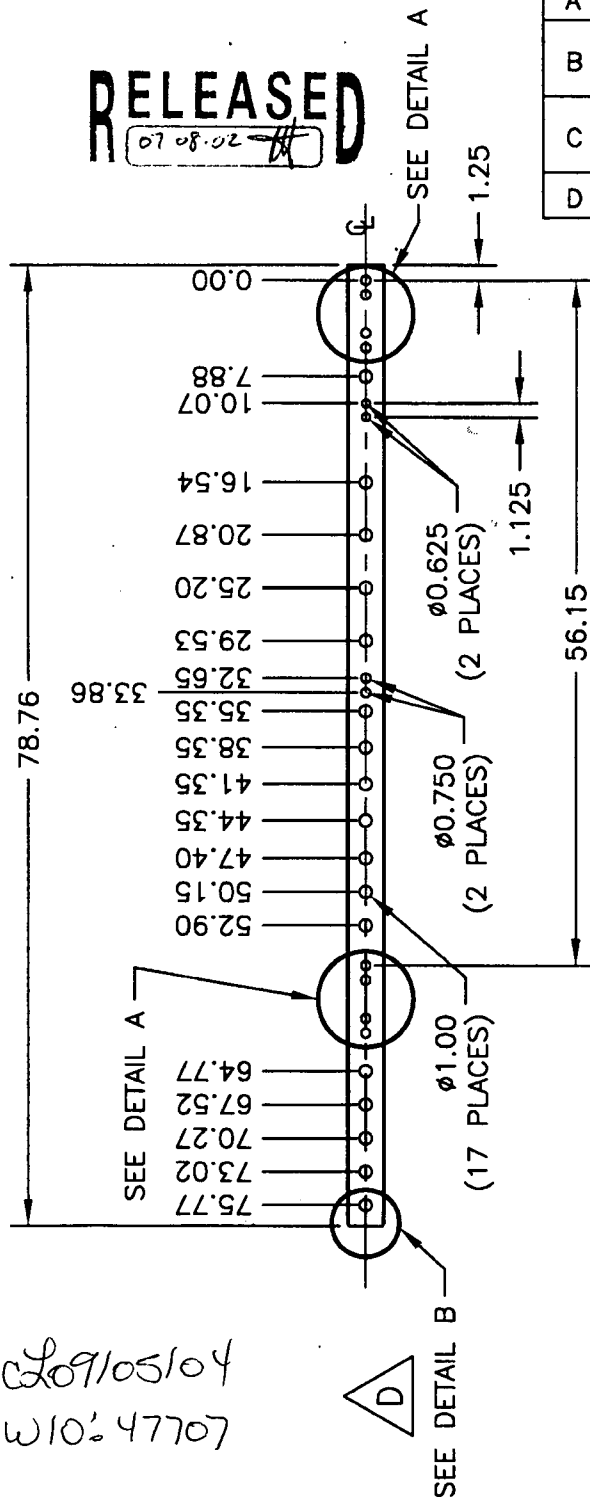
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <b>PH</b>		DRAWN BY <b>CB</b>		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>		APPROVED <b>[Signature]</b>		DRAWING NO. D2739 REV. D SHEET 1 OF 1	
DATE 07.05.29		TITLE WEB		SCALE 1:15	
A	98.04.16	NEW ISSUE			
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS			
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS			
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B			



**NOTES:**

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT  $\phi$

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